

17

Date: Monday, 3/17/2008 11:58:17 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BASKET LID ASSEMBLY		
Job Number	38046A					
Estimate Number	10853					
P.O. Number	:		Part Number	:	D3325041	
This Issue	: 3/17/2008	S.O. No. :	Drawing Number	:	D3325 REV B	
Prsht Rev.	: NC		Project Number	:	N/A	
First Issue	: / /	Type : LARGE FAB ASSY	Drawing Revision	:	B	
Previous Run	: 37560A		Material	:		
Written By	:		Due Date	:	4/21/2008	Qty: 1 Um: Each
Checked & Approved By	:	080318				
Comment	Est Rev:A 05.02.09 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33281	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
	2 D3328-1	Hinge Plate 334123✓	
2.0	D33491	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
	2 D3349-1	Spacer Bushing 334205✓	
3.0	D33521	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
	2 D3352-1	Label Plate 334206✓	
4.0	D33671	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
	2 D3367-1	Mounting Bracket 334207✓	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 38046A

Part Number: D3325041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 21.5687 f(s)/Unit Total : 21.5687 f(s)

Material: 4130 Cond. N Square tube per MIL-T-6736,

1/2" x 0.035" wall

M4130N-TS0.500W.035)

PL 08-04-04

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2 D3325-1 EndTube

405533



3 D3325-3 Interior Tube

105533 (2) 47679 (1)

2 D3325-5 Full Length Tube

105533

Identify parts appropriately

SAD 08/04/04



2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004

A/RNA/Steel Rod M100075

4-Deburr as required

PL 08-04-05

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 08/04/14

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PL 08/04/14

9.0 POWDER COATING POWDER COATING



m107550

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PL 08/04/14

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08/04/15

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 08/04/15

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15 JF

Job Completion



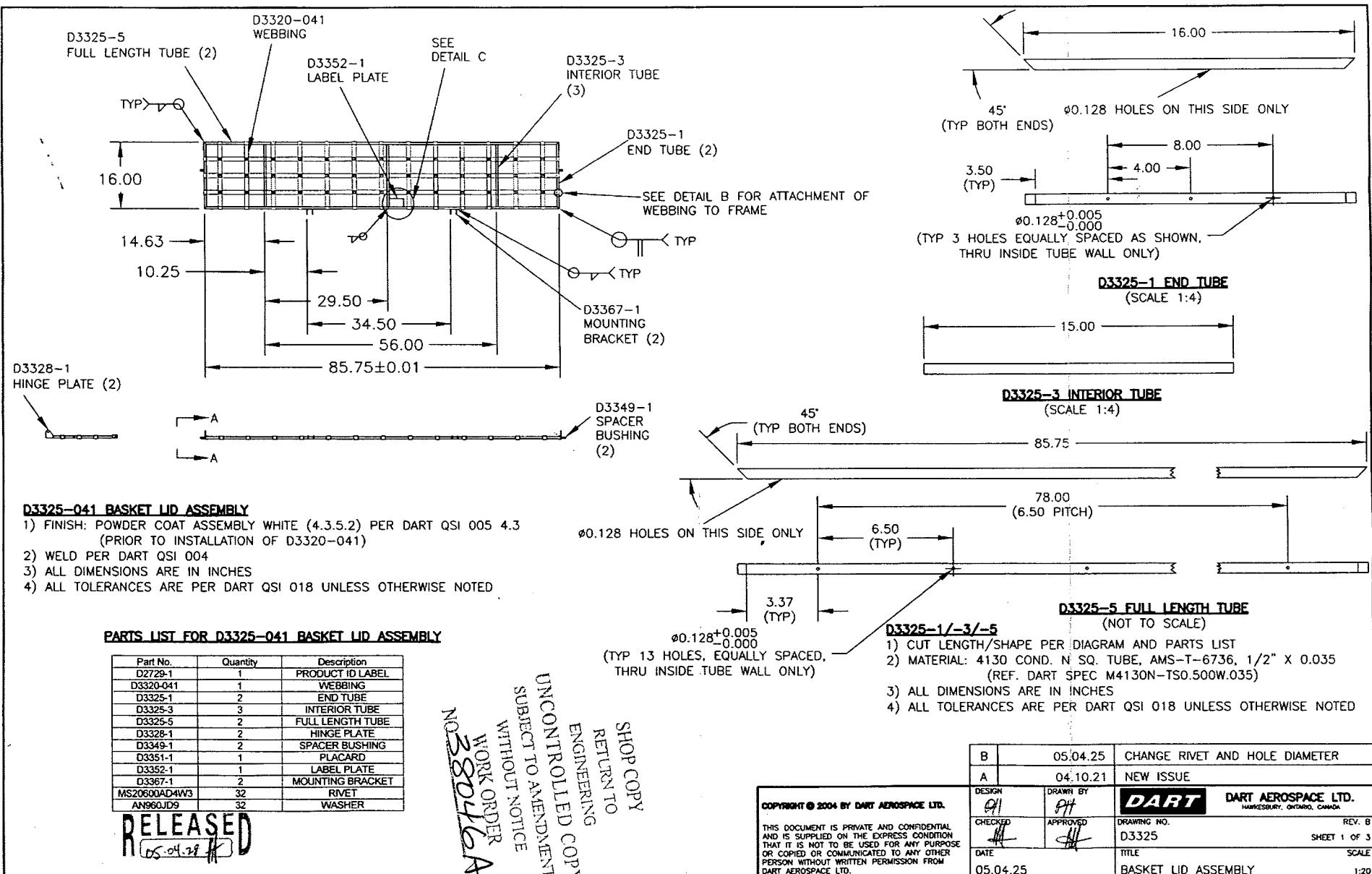
9 08/04/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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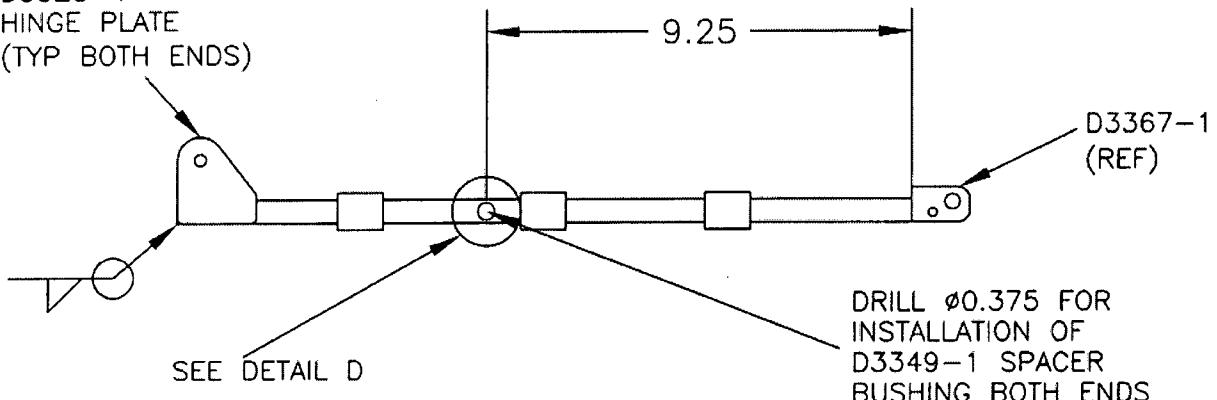
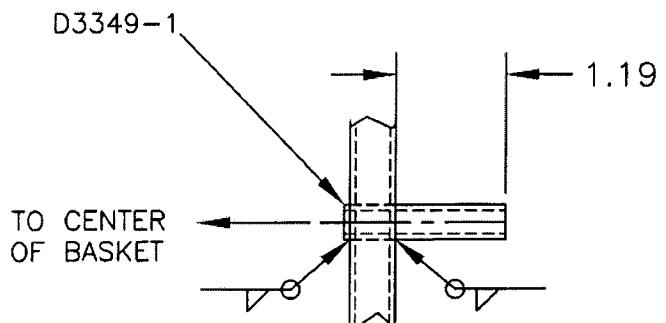
NOTE: Date & initial all entries



DART

DESIGN <i>AH</i>	DRAWN BY <i>AH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

D3328-1
HINGE PLATE
(TYP BOTH ENDS)

VIEW A-A

DETAIL D
(SCALE 1:2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *38046A*

RELEASED
05.04.28 *#*

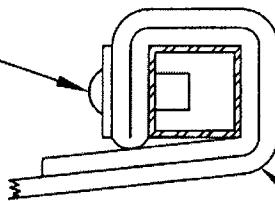
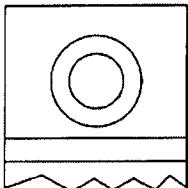
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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY	SCALE 1:4	

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

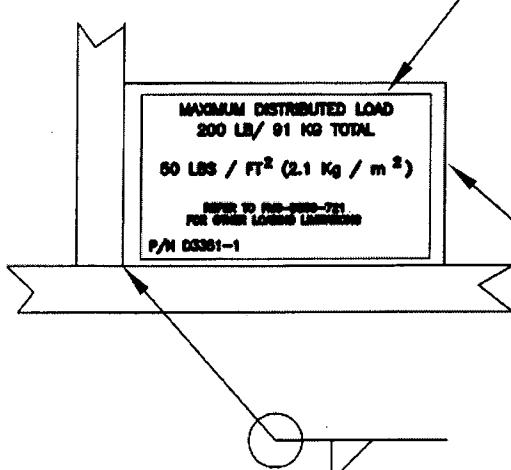


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28 *PH*

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

SHOP COPY
RETURN TO
ENGINEERING
OUTBOARD
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38046A

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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